

Date: Friday, 9/7/2007 10:14:51 AM
User: Kim Johnston

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : TAIL LIGHT FAIRING

Job Number : 34463 - 2

Estimate Number : 12418

P.O. Number :

Part Number : D3484042

This Issue : 9/7/2007 S.O. No. :

Drawing Number : D3484 REV D

Prsht Rev. : NC

Project Number : N/A

First Issue : 1/1 Type : LARGE FAB ASSY

Drawing Revision : D

Previous Run : 34451

Material :
Due Date : 9/30/2007

Qty: 8 Um: Each

Written By : Kim Johnston

Checked & Approved By : Kim Johnston

Comment : Est Rev: A New Issue 06-05-23 EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D34842

BASE, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

BASE, RH

Batch: B34457-1 6x

Ref 08/01/15

2.0

D34844

FACE, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

FACE, RH

Batch: B34459 6x

Ref 08/01/15

Pho

3.0

D34846

CONE, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

CONE, RH

Batch: B34461 6x

Ref 08/01/15

4.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig

A/R AL ROD Batch: 4104855

2-Buff & Smooth Welds to mating surfaces

Ref 08/01/17 6x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3484-042 PAR #: N/A Fault Category: Prod. Defect NCR: Yes No DQA: NA Date: 08.01.24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/24	#20/40	D3484-4 was SCRAP During welding Employee heated the part too much During welding and warped it	<i>[Signature]</i>	SCRAP and destroy D3484-4. Replace only in welding. B# 34459	<i>[Signature]</i> 08/01/24	<i>[Signature]</i> 08/01/24	<i>[Signature]</i>	<i>[Signature]</i> 08/01/24

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 34463

Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-18 (6)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50601/01 (6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

52 08-01-22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

08/01/23

9.0

MS20426AD33

CRW22-3-02.5

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit

Total: 40.0000 Each(s)

24.000

Rivet

Batch:

M106878

FF 08-01-23

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit

Total: 20.0000 Each(s)

12.000

ANCHOR NUT

Batch:

M103693

FF 08-01-23

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

FF 08-01-23

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

080123 (6)

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Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

POWDER COATING

POWDER COATING



M 106379



(6x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h

08/01/23

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

08-01-24

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-142 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

PO

08/01/24

(6)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.24

Job Completion



08/01/24

(6)

15 B

Inspect level 5
Check P/N To Drawing

PK

Permanent Change

18

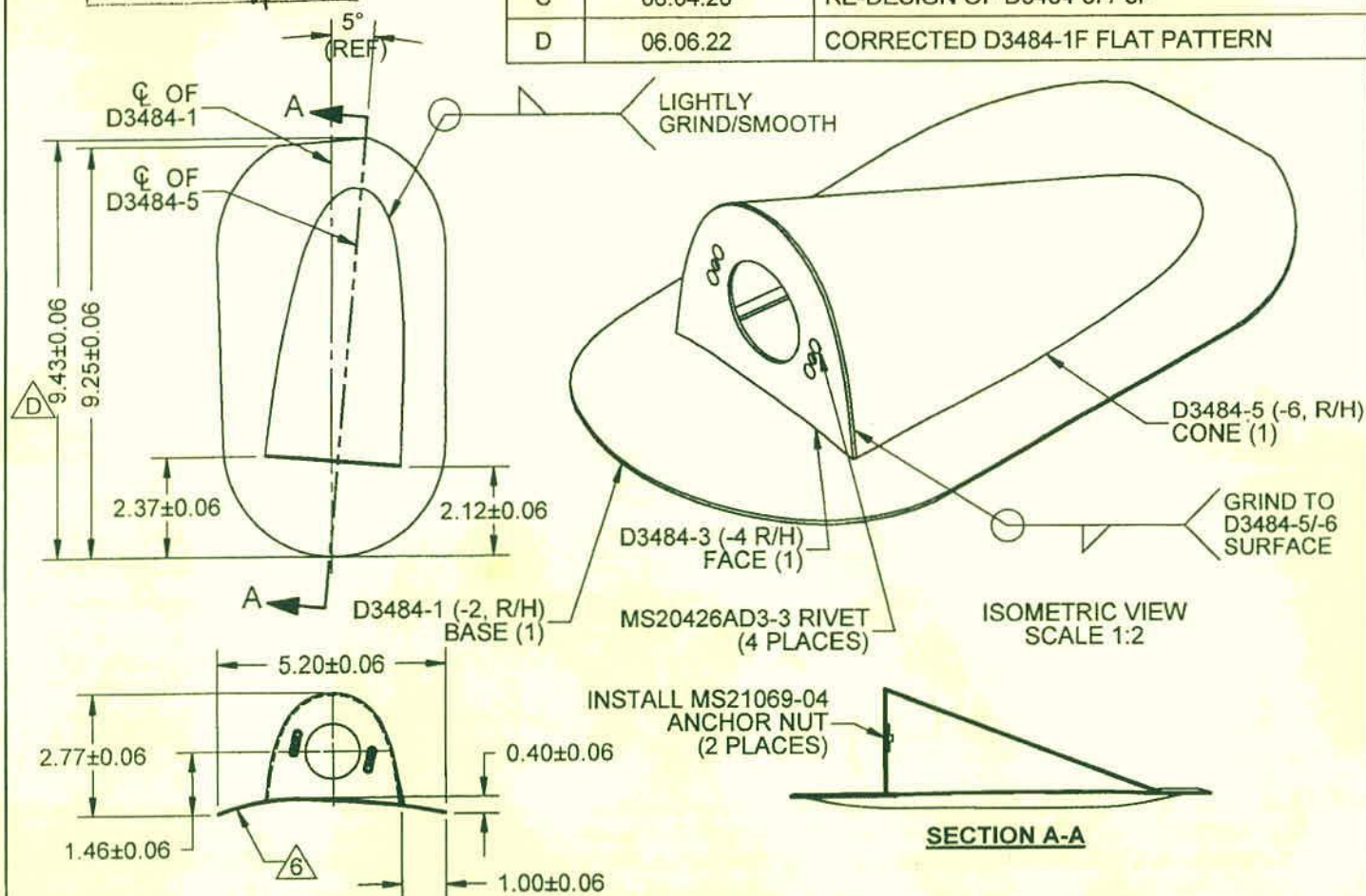
08/01/24 (6)

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3484	REV. D SHEET 1 OF 4
DATE 06.06.22	TITLE TAIL LIGHT FAIRING SCALE 1:4		
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	

RELEASED

06.08.17

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD.,
P/N D412-750-141/-142 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE
PDA06-13"

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H) SHOP COPY
1		D3484-3	FACE (L/H) RETURN TO
	1	D3484-4	FACE (R/H) ENGINEERING
1		D3484-5	CONE (L/H) UNCONTROLLED COPY
	1	D3484-6	CONE (R/H) SUBJECT TO AMENDMENT
			WITHOUT NOTICE
4	4	MS20426AD3-3	RIVET WORK ORDER
2	2	MS21069-04	ANCHOR NUT NO. 3446-3

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